

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claim 1. (cancelled)

Claim 2. (cancelled)

Claim 3. (currently amended) The roll according to claim 8 30, wherein the roll is a developer roll.

Claim 4. (currently amended) The roll according to claim 8 30, wherein the polydiene is polydiene diol or polydiene prepolymer.

Claim 5. (currently amended) The roll according to claim 8 30, wherein the urethane prepolymer comprises polycaprolactone ester toluene diisocyanate prepolymer.

Claim 6. (original) The roll according to claim 4, wherein the polydiene diol comprises polybutadiene diol.

Claim 7. (cancelled)

Claim 8. (cancelled)

Claim 9. (currently amended) The roll according to claim 8 30, wherein the conductive modifier is selected from the group consisting of ferric chloride, ferrous chloride, calcium chloride, cobalt hexafluoroacetylacetone and combinations thereof.

Claim 10. (previously presented) The roll according to claim 9, wherein the conductive modifier comprises ferric chloride.

Claim 11. (currently amended) The roll according to claim 8 30, wherein the hydrolytic stabilizer comprises triisopropanolamine.

Claim 12. (currently amended) The roll according to claim 8 30, exhibiting a Shore A hardness of less than about 50 according to ASTM D2240-86 and a compression set of less

than about 8% according to ASTM D395-89, method B, at a temperature of about 70°C for about 22 hours.

Claim 13. (currently amended) An image forming device comprising a roll as recited in claim 8 30.

Claim 14. (original) The image forming device according to claim 13, wherein the image forming device comprises an electrophotographic printer.

Claim 15. (previously presented) A developer roll for an image forming device, comprising a polyurethane elastomer formed from a polyurethane mixture, wherein the polyurethane mixture comprises polycaprolactone urethane prepolymer, polybutadiene diol, tri-functional polyol curative, a grafted polymer curative having two hydroxy groups and a silicone side chain, conductive modifier comprising ferric chloride, hydrolytic stabilizer comprising triisopropanolamine, and antioxidant comprising 2,6-di-tertiarybutyl-4-methyl-phenol, wherein the developer roll exhibits a Shore A hardness of less than about 50 according to ASTM D2240-86 and a compression set of less than about 5% according to ASTM D395-89, method B, at a temperature of about 70°C for about 22 hours.

Claim 16. (cancelled)

Claim 17. (cancelled)

Claim 18. (currently amended) The method according to claim 22 31, wherein the urethane prepolymer comprises polycaprolactone ester toluene diisocyanate prepolymer.

Claim 19. (currently amended) The method according to claim 22 31, wherein the polydiene is polydiene diol or polydiene prepolymer.

Claim 20. (original) The method according to claim 19, wherein the polydiene diol comprises polybutadiene diol.

Claim 21. (cancelled)

Claim 22. (cancelled)

Claim 23. (currently amended) The method according to claim 22 31, wherein the conductive modifier is selected from the group consisting of ferric chloride, ferrous chloride, calcium chloride, cobalt hexafluoroacetylacetone and combinations thereof.

Claim 24. (original) The method according to claim 23, wherein the conductive modifier comprises ferric chloride.

Claim 25. (currently amended) The method according to claim 22 31, wherein the hydrolytic stabilizer comprises triisopropanolamine.

Claim 26. (currently amended) The method according to claim 22 31, wherein the antioxidant comprises 2,6-di-tertiarybutyl-4-methyl-phenol.

Claim 27. (currently amended) The method according to claim 22 31, wherein the roll has a hardness of less than about 50 Shore A according to ASTM D2240-86 and a compression set of less than or about 8% according to ASTM D395-89, method B, at a temperature of about 70°C for about 22 hours.

Claim 28. (currently amended) The method according to claim 22 31, wherein the outer layer has a resistivity from about  $5.0 \times 10^9$  ohm-cm to about  $2.0 \times 10^{12}$  ohm-cm.

Claim 29. (previously presented) A method of manufacturing a roll, comprising:

a) casting a polyurethane mixture into a mold, the polyurethane mixture comprising polycaprolactone urethane prepolymer, polybutadiene diol, tri-functional polyol curative, a grafted polymer curative having two hydroxy groups and a silicone side chain, conductive modifier comprising ferric chloride, hydrolytic stabilizer comprising triisopropanolamine, and antioxidant comprising 2,6-di-tertiarybutyl-4-methyl-phenol, wherein the developer roll exhibits a Shore A hardness of less than about 50 according to ASTM D2240-86 and a compression set of less than about 5% according to ASTM D395-89, method B, at a temperature of about 70°C for about 22 hours.

- b) curing the polyurethane mixture to allow demolding of a resulting roll;
- c) demolding the roll and, optionally, post-curing the demolded roll;
- d) grinding the roll to desired dimensions; and

e) baking the roll under conditions sufficient to oxidize an outer layer of the roll, wherein the outer layer has a resistivity from about  $5.0 \times 10^9$  ohm-cm to about  $2.0 \times 10^{12}$  ohm-cm.

Claim 30. (previously presented) A roll comprising a polyurethane elastomer formed from a polyurethane mixture, wherein the polyurethane mixture comprises urethane prepolymer, polydiene, tri-functional polyol curative, an additional graft polymer curative having a molecular weight of at least about 800 and comprising at least two hydroxy and/or amino groups, conductive modifier, hydrolytic stabilizer, and, optionally, antioxidant; wherein the additional graft polymer curative having the at least two hydroxy and/or amino groups comprises at least one acrylate, silicone or polyester side chain.

Claim 31. (previously presented) A method of manufacturing a roll comprising:

a) casting a polyurethane mixture into a mold, the polyurethane mixture comprising urethane prepolymer, polydiene, tri-functional polyol curative, from about 9% to about 40% by weight of an additional graft polymer curative having a molecular weight of at least about 800 and comprising at least two hydroxy and/or amino groups, conductive modifier, hydrolytic stabilizer, and, optionally, antioxidant.

- b) curing the polyurethane mixture to allow demolding of a resulting roll;
- c) demolding the roll and, optionally, post-curing the demolded roll;
- d) grinding the roll to desired dimensions; and
- e) baking the roll under conditions sufficient to oxidize an outer layer of the roll,

wherein the additional graft polymer curative having the at least two hydroxy and/or amino groups comprises at least one acrylate, silicone or polyester side chain.

Claim 32. (new) The roll according to claim 30, wherein the additional graft polymer curative further comprises a polyether side chain.